## Work Order ID 57972

April 21, 2010 9:27:22 AM

Item ID:

D4038-8

Block

**Revision ID:** 

Item Name:

**Start Date:** 23/04/2010

Start Qty: 4.00 Req'd Qty: 4.00 **Required Date:** 30/04/2010

Operation

Description

Reference:

**Approvals:** 

QC:

**Process Plan:** 

В

Date:

Date:

SPC (Y/N):

Accept

**Tooling:** 

Set Up/

**Run Hours** 

Draw Number

**Cust Item ID:** 

**Customer:** 

Draw Rev.

Plan Code Accept **Qty** 

Reject **Qty** 

Run

Setup Start

Stop

Start

Stop

Reject Number Stamp

Insp.

Draw Nbr

**Work Center ID** 

Sequence ID/

**Revision Nbr** 

D4038

Bandsaw

Jeaspa Bandsaw

Memo

CUT BLANK 2.125" LONG

0.00

0.00

onf 10/04/24

Date:

Date:

105

HAAS 1

HAAS CNC vertical machine #1

Memo

Mill as per Dwg and Folio FA884

DWG REV: FOLIO REV: A

**DEBURR** 

0.00

0.00

and 10/04/25

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23/04/2010

Start Qty: 4.00 Req'd Qty: 4.00

**Required Date: 30/04/2010** 



Accept

Setup Start

Stop

**Cust Item ID:** 

**Customer:** 

Draw

Ba idoulas.

Number

Reference:

Approvals:

**Process Plan:** 

Date: Date: **Tooling:** 

SPC (Y/N):

Date:

Date:

Draw

Rev.

Run

Reject

Start



Number Stamp

Insp.

Stop

Reject

Sequence ID/ **Work Center ID** 

110

Quality Control

**Operation Description** 

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/ Run Hours

0.00

0.00

Qty Code

Accept

Plan

Qty

120

Quality Control

QC8- Inspect parts - second check

0.00

0.00

Memo

130

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

A St 10-4-26.

0.00

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Block

QC:

**Start Date:** 

23/04/2010

Start Qty: 4.00 Req'd Qty: 4.00 **Required Date:** 30/04/2010

Accept



Setup Start





**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

**Process Plan:** 

Date: Date: **Tooling:** 

SPC (Y/N):

Date: Date:

Draw

Rev.

Run

Start

Stop



Sequence ID/

**Work Center ID** 

150

Quality Control

**Operation** Description

QC3- Inspect Part Finish

Memo

Set Up/

**Run Hours** 0.00

0.00 M 10/04/26

Draw

Number

x 4

Accept

Qty

Plan

Code

Qty Ø

Reject

Reject Number Stamp

Insp.

160

Packaging

Packaging

Identify as per dwg & Stock Location: // O

Memo

0.00

0.00

1/10/1/26 (4)

170

Quality Control

QC21- Final Inspection - Work Order Release

Memo

0.00

0.00

## **Picklist Print**

April 21, 2010 9:27:22 AM

Work Order ID: 57972

Parent Item Name:

D4038-8

Comments:

Parent Item:

Block

Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Start Date: 23/04/2010

Required Date: 30/04/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name

Item ID

Replacement Mfg/ Purch

Primary Item Location

Last Location

Route Seq 1D Unit of Qty on Measure Hand

Remaining Qty To Pick

Qty Issued Date Issued

Status

M6061T6B1.500X02.00

Purchased

No

9.5000

0.6989

6061-T6 Bar 1.50 x 2.00

Warehouse Loc Qty Loc Code Location Main Warehouse MAT10 9.5 110167 9.5

10/04/24

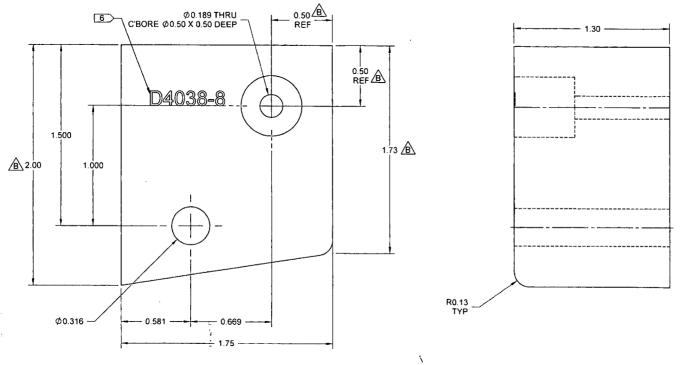
DART AEROSPACE LTD	Work Order:	57972
Description: 3/10ck	Part Number:	D4038-8
Inspection Dwgl > 403 \ Rev: 73		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST								
		Х	First Artic	le	Prote	otype		
Drawing Dimension	Tolerance		Actual Dimension	Accept	Reject	Method of Inspection	Co	omments
1.30	±-036		1.299					
R.13	±030		R.130					
2.00	I-036		1.998					
1.500	=-010		1,500		: .			
1.000	= 005		1.000				-	
Ø.316	+.006		8.317					
581	+-016		.581					
669	± 005		.669					
1.75	=-030		1.757					
L73 · ·	1 .		1.730					
SO	=-030		.500					
500	=-030		- 500					
8.189	+-005		9.191	<i>—</i>				
X ST X SODE	P = -630X=	030	Ø.500X.500	2				
				1	· · · · · ·	D-4-4 4	neo cole	N/A
Measured by:	any	_   -	Audited by:	M.A	12	Prototype Ap		
Date:	10/04/25		Date:	10/04	16		Date:	N/A

			1/4 2	Destatura Approval:	N/A
Measured by:	and	Audited by:	M.A	Prototype Approval:	14/7
Date:	10/04/20	Date:	10104/26	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	

w/o 57972



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04038-8

D

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**D4038-8 BLOCK** 

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. B D4038 MFG. APPR. SHEET 10 OF 14 APPROVED TITLE SCALE **BRACKET** DE APPR. THIS DOCUMENT IS PROVIDED AND THE CONTROL AND IS SUPPLED ON THE CONTROL AND TO BE USED FOR ANY PURPOSE OF COMED OF COMMENCENTED TO ANY OTHER PURPOSE OF COMED OF COMMENCENTED TO ANY OTHER PURPOSE. DATE 10.01.05

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